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(54) METHOD FOR REMOVING CORE SAND OF CASTING

(57) Abstract:

PURPOSE: To satisfactorily remove core sand with high thermal efficiency in a short period by holding disintegrated castings for a prescribed period in a fluidized bed of molding sand or alumina particles having the same grain size as the grain size of the core sand at a prescribed temp., thereby solutionizing the castings.

CONSTITUTION: The disintegrated castings are put into the fluidized bed in a fluidized bed furnace of the molding sand or alumina particles having the same grain size as the grain size of the core sand at 350W560°C, more preferably 490°C solutionization treatment temp. and are held therein for 4hr. The castings are uniformly solutionized without local overheating and the adhesive agents of the core sand are thermally decomposed, by

which the core sand is easily removed. The need for removing the core sand by separately heating the same after cooling is, therefore, eliminated, by which the thermal efficiency is improved and the automation of the treatment is permitted.

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